

Work Order ID 144287***144287***

Page 1

Tuesday, April 12, 2016 10:21:39 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rear Locker Extender

Start Date: 4/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/17/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DAS
13
9-89Date: **APR 12 2016**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject DAS Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2273	L								
D350-604-041	C								
100	Document Control	OCT 04 2016	DAS 6 9-89						
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-604-041 CHG009								
110	PURCHASING	0.00							
110									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 32014 Description: D350-604-041 Rear locker extender. Manufacture as per dwg D2273 Supplier: FDC Composites Inc. Certification of Conformity and process sheet required.								

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

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Tuesday, April 12, 2016 10:21:39 AM

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rear Locker Extender
Start Date: 4/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/17/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Packaging Memo Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached. ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***	0.00 0.00							
130 *130* QC Quality Control	QC6- Inspect dimensions to drawing Memo Check hole locations to template. DT 8824 Check process sheet and audit. FDC ED# DAE 001-104	0.00 0.00							DAS 16 9-89 10/09/27
140 *140* Small Fab Small Fab	 Memo 1- INSTALL DECALS AS PER DWG	0.00 0.00							1 DAS 28 9-89 OCT 12 2016

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Tuesday, April 12, 2016 10:21:39 AM

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 4/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/17/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
							DAS 27 9-89		
									OCT 12 2016
155	Pick Kit	0.00							
155									
Packaging	Memo	0.00							
Packaging	***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***								
									OCT 04 2016
158	QC4- 100% Inspect kits for completeness	0.00							
158									
QC	Memo	0.00							
Quality Control									
							DAS 28 9-89		OCT 12 2016

Tuesday, April 12, 2016 10:21:39 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Locker Extender

Start Date: 4/12/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/17/2016 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: F9108

PPP Rev: _____

DAS 27 9-89 DAS 28 9-89 OCT 12 2016

170

QC21- Final Inspection - Work Order Release

0.00

170

Memo

0.00

QC

Quality Control

DAS
21
9-89

OCT 1 2 2016

DAS
21
9-89

OCT 1 2 2016

Picklist Print

Tuesday, April 12, 2016 10:21:37 AM

Page 1

Work Order ID: 144287

144287

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/12/2016

Required Date: 8/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and
washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2268 *D2268* Placard		Manufactured	No			140	Each	36.0000	1	1			
									**			OCT 04 2016	DAS 6 27 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST006				36					
				130951				1					
				132546				11					
				141996				12					
				143806				12					
D2269 *D2269* Placard		Manufactured	No			155	Each	29.0000	1	1		OCT 04 2016	DAS 6 27 9-89 9-89
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST006				29					
				131139				5					
				135175				12					
				143807				12					
D2728-1 *D2728-1* Dart Logo Label Small		Manufactured	Yes			140	Each	0.0000	1	1			DAS 27 9-89
D350-604-041P *D350-604-041P* Rear Locker Extender		Purchased	No			110	Each	0.0000	1	1			1x 80 16-9-27
									**				

Picklist Print

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Tuesday, April 12, 2016 10:21:37 AM

Work Order ID: 144287

144287

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/12/2016

Required Date: 8/17/2016

Start Qty: 1.00

Required Qty: 1.00

D5062-041

Manufactured No

155

Each

16.0000

1

1

D5062-041

Bracket Assembly

**

OCT 11 2016

DAS 6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST147

16

130525

14

131060

2

143454

Tuesday, April 12, 2016 10:21:37 AM

Shop Packet Print

Page 2

W/O: 144287

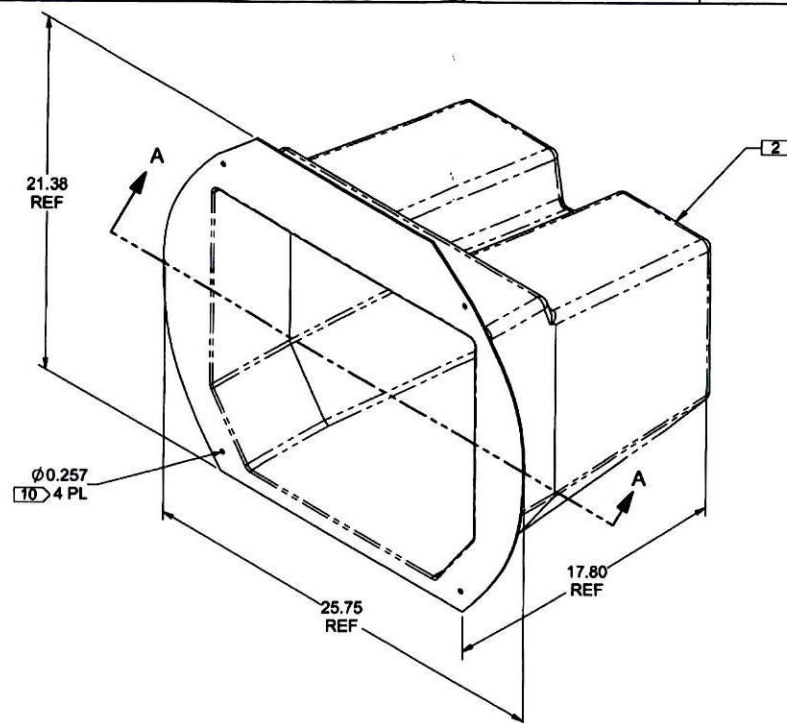
APR 12 2016

TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

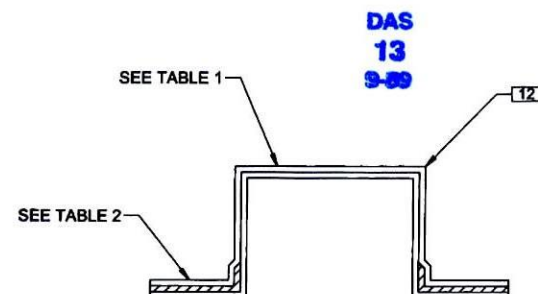
POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER



D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	POLYCOR 2330PAWK745 (WHITE)
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)



SECTION A-A

NOTES:

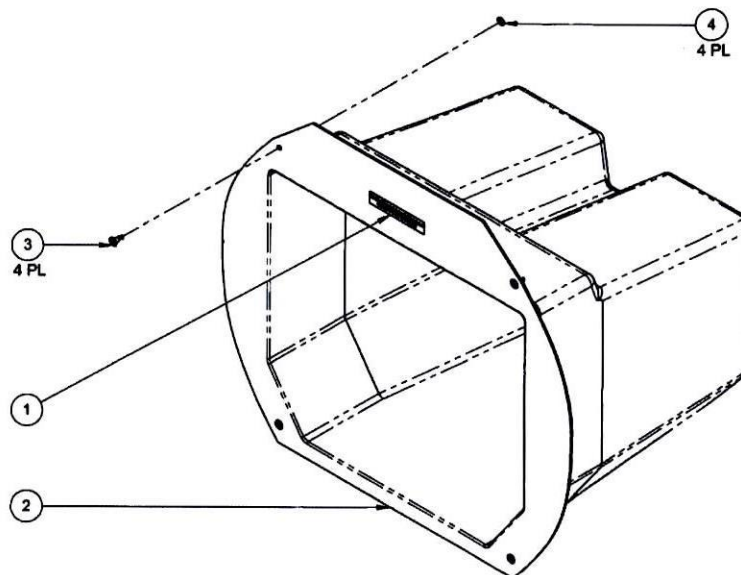
- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
ACCEPTABLE TO COVER CRACKS IN GELCOAT BY APPLYING A LAYER OF PPG 6941241A 2C ACRYCOTE WHITE PAINT OVER GELCOAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5~ 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

RELEASED
2015-11-03
EN 15-637

L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MATL PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN 85-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	AP	DRAWING NO.	REV. L
MFG. APPR.	JLM	D2273	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	350 REAR LOCKER EXTENDER	NTS
DATE	15.10.19	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
1	1	D2268	PLACARD
2	1	D2273	REAR LOCKER EXTENDER
3	4	2600-6	CAMLOCK STUD
4	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 5.5 to 7.5 lbs
 - 8) INSTALL D2268 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

C	REMOVE D2728-1, D2729-1 DECALS (ZN C5-1) REVISED RELATED NOTES, UPDATED PART WEIGHT	ML	13.12.16
B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS. ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1), ADD D2729-1 (ZN C5-1).	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D350-604-041	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RLE ASSY	NTS
DATE	14.01.02	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32014**

Purchase Order Date 4/12/2016

PO Print Date 4/12/2016

Page Number 1 of 5

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAIL

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

APR 13 2016

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D350-604-041P AS PER DWG.D2273 REV.L B144287	Rear Locker Extender	8/17/2016 Yes 8/17/2016		1.00 Each	\$835.00	\$835.00
Line Total:							\$835.00
2	D350-604-041P AS PER DWG.D2273 REV.L B144288	Rear Locker Extender	8/17/2016 Yes 8/17/2016		1.00 Each	\$835.00	\$835.00
Line Total:							\$835.00
3	D350-604-041P AS PER DWG.D2273 REV.L B144289	Rear Locker Extender	8/17/2016 Yes 8/17/2016		1.00 Each	\$835.00	\$835.00

8016-9-27

25/8/16
30

Note:

4/12/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5 **Tél.: 450 357-1344**

Bon de livraison 22/09/2016

Commande : 2463 Rev. B
Référence : PO #32014/1-10

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à
DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7 **Tél.: 1 613 632-9577**

No item	Description	Qté	Qté livrée	Qté B/O
D350-604-041P	REAR LOCKER EXTENDER PO item: 32014/1 Lot: 2016-06-02, DAE001-104 As per DWG.D2273 Rev .L B144287	1	1	0
D350-604-041P	REAR LOCKER EXTENDER PO item: 32014/2 Lot: 2016-05-26, DAE001-097 As per DWG.D2273 Rev .L B144288	0	1	0
D350-604-041P	REAR LOCKER EXTENDER PO item: 32014/3 Lot: 2016-05-30, DAE001-099 As per DWG.D2273 Rev .L B144289	1	1	0
D350-604-041P	REAR LOCKER EXTENDER PO item: 32014/4 Lot: 2016-05-26, DAE001-097 As per DWG.D2273 Rev .L B144290	0	1	0
D350-604-041P	REAR LOCKER EXTENDER PO item: 32014/5 Lot: 2016-06-01, DAE001-103 As per DWG.D2273 Rev .L B144291	0	1	0
D350-604-041P	REAR LOCKER EXTENDER PO item: 32014/6	0	1	0

8016 9-27

*** Suite autre page ***

CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 32014

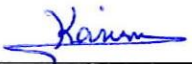
Rev. NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B144287	DAE001-104	2016-06-02
3	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B144289	DAE001-099	2016-05-30
7	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B144293	DAE001-105	2016-06-02
8	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B144294	DAE001-090	2016-06-19
9	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B144295	DAE001-088	2016-05-19

NOTE : Paint process : interior surface re-painting as specified on Darts's PO by sanding gelcoat to remove cracks and application of PPG 6941241A 2C Acrycote White paint Lot 01516. Catalyst was PPG 794002 2C Acrycote Lot 98841.

Catalysed PPG acrycote paint complies with FAR 25.853 Appendix F Part I (b)-Par.4 (Vertical Test 60 seconds).

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Karim Malihi, B Eng, Quality Manager

Date: 2016 Sept 22